

# Work Order ID 72607

Wednesday, August 03, 2011 1:13:05 PM



For Friday

Page 1

Item ID: D4006-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Top Support Assembly

Start Date: 8/3/2011 Start Qty: 6.00

Required Date: 8/8/2011 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-08-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4006

A

100

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D4006

8/5/08/10

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/08/10

(+2)

120

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

1117332

Memo

0.00

Powder Coating

Start Time: 7:30 AM  
Oven Temperature: 320°F  
Finish Time: 8:00 PM

2 8/10/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							<i>EP 11/08/11</i> (2)
140  HandFinish Hand Finishing	Memo 1- Apply glue and install Foam as per dwg Batch: <i>M117780</i> 2- Install anchor nuts as per dwg	0.00  0.00							<i>EP 11/08/11</i> (2)
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							(+2)

*Sulosly*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Stop



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Start Date: 8/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 107

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

4/11/11 OK 11/08/1211-08-12  
(2)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 03, 2011 1:13:10 PM

Page 1

Work Order ID: 72607

Parent Item: D4006-041

Parent Item Name: Tank Top Support Assembly





Start Date: 8/3/2011

Required Date: 8/8/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A 09.12.18 new issue Prelim EC verified by:DD IPP Rev:B  
10.05.03 as per ECN10-562 DD verified by:EC  
IPP Rev:C 10.07.12 added type of glue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4006-1  Angle		Manufactured	No			100	Each	14.0000	1	6		8/11/08/10	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				GA				14					
					70187			14					
D4006-3  Channel		Manufactured	No			100	Each	9.0000	2	12		8/11/08/10	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST107				9					
					71403			9					
MS20470AD4-5  Rivet, Universal Head		Purchased	No			100	Each	3,343.000	8	48		8/11/08/10	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST319				3343					
					116893			343					
					118405			3000					
D4006-5  Foam		Manufactured	No			140	Each	10.0000	1	6		8/11/08/10	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST107				10					
					63940			10					

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 2

Work Order ID: 72607

Parent Item: D4006-041

Parent Item Name: Tank Top Support Assembly

Start Date: 8/3/2011

Required Date: 8/8/2011

Start Qty: 6.00

Required Qty: 6.00

MS20426AD3-4

Purchased

No

140

Each

5,068.000

4



RIVET

Location

Loc Qty

Loc Code

ST316

5068

104374

1142

110398

3926

MS21059L4

Purchased

No

140

Each

21.0000

2



Nutplate

Location

Loc Qty

Loc Code

ST301

21

117887

21

24  
8/11/08/11

8  
12  
8/11/08/11

4

Wednesday, August 03, 2011 1:13:10 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

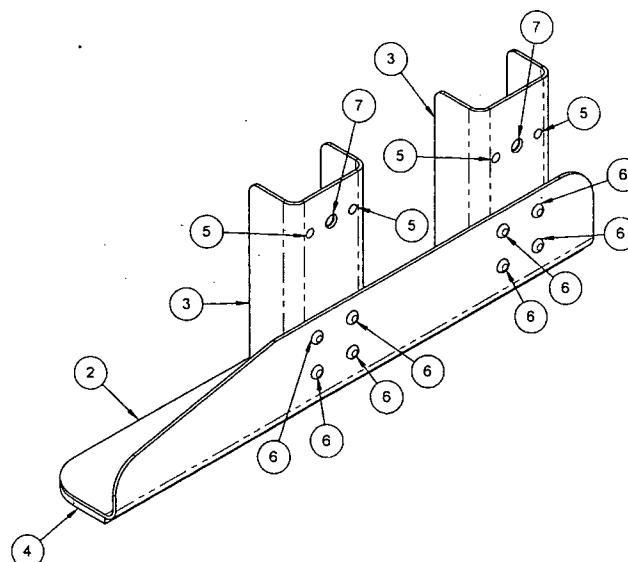
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4006-041	TANK TOP SUPPORT ASSEMBLY	JCA-M47-2-01
2	1	D4006-1	ANGLE	
3	2	D4006-3	CHANNEL	
4	1	D4006-5	FOAM	
5	4	MS20426AD3-4	RIVET	
6	8	MS20470AD4	RIVET	
7	2	MS21059-4	ANCHOR NUT	



**D4006-041 TANK TOP SUPPORT ASSEMBLY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 72687

111083

RELEASED  
2010-05-05  
MD

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3  
BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4006-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.47 lbs

A	NEW ISSUE		10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.05		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO. <b>D4006</b>	SHEET 1 OF 6	
TITLE <b>UPPER RESTRAINT</b>	SCALE NTS	
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

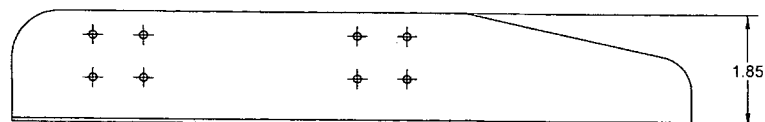
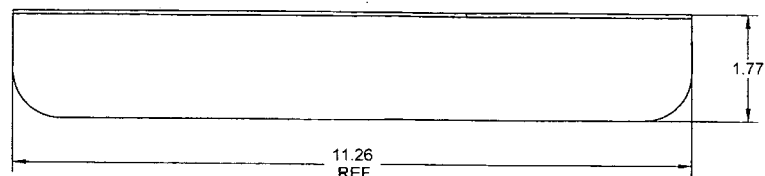
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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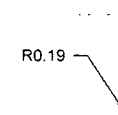
**NOTE:** Date & initial all entries

DART AEROSPACE  
PART NUMBER  
D4006-1

JOHN CAMERON AVIATION  
PART NUMBER  
REF JCA-M47-2-01



D4006-1 ANGLE



**NOTES:**

- 1) MATERIAL: MADE FROM D4006-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4006	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		UPPER RESTRAINT	NTS
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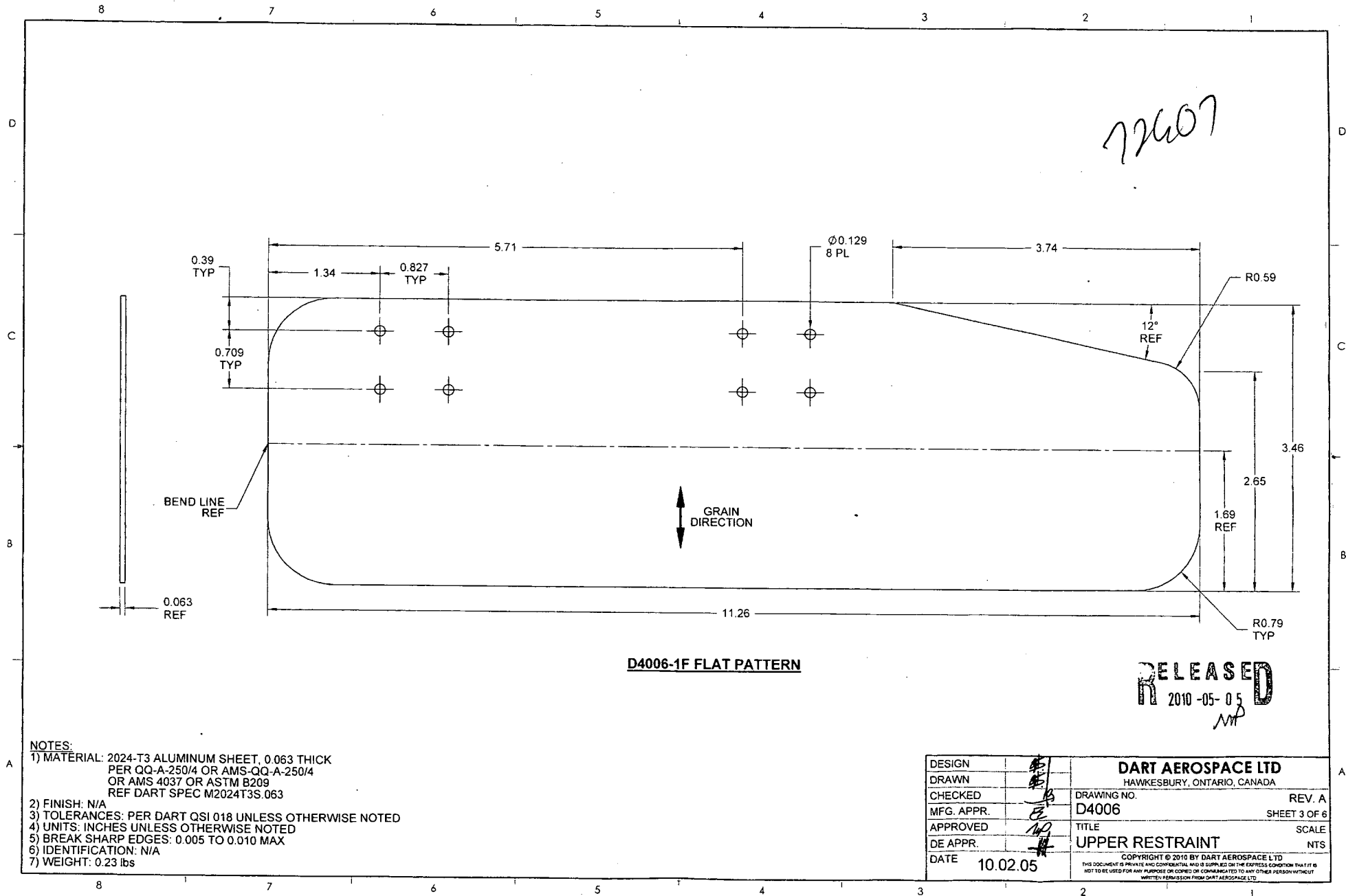
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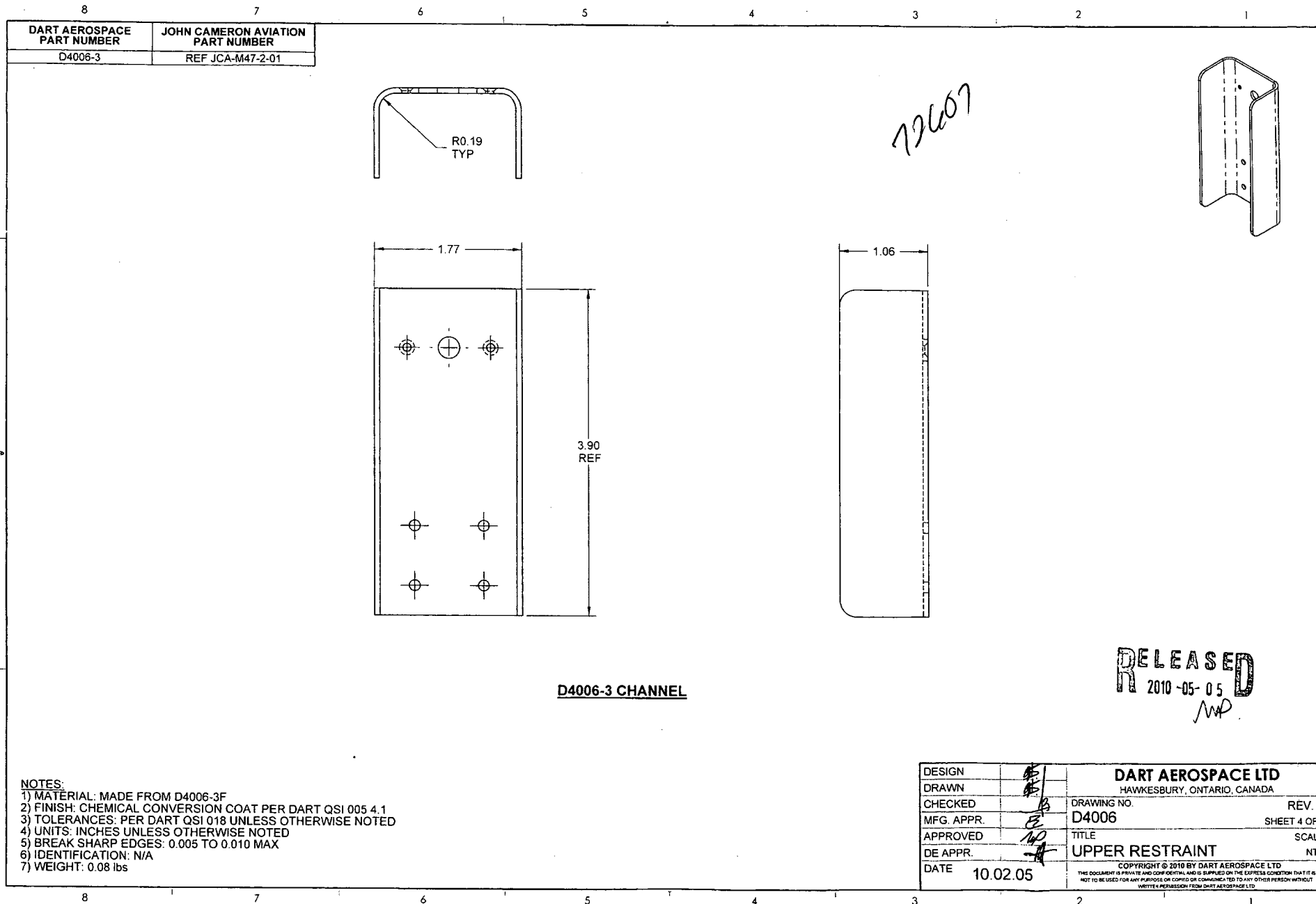
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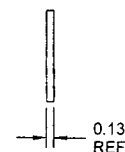
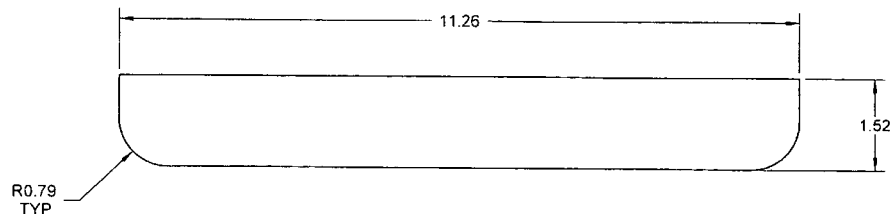
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-5	REF JCA-M47-2-01



**D4006-5 FOAM**

**RELEASED**  
2010-05-05  
*MD*

**NOTES:**

- 1) MATERIAL: BLACK NEOPRENE/EPDM/SBR BLEND SHEET, 0.125 THICK  
PER ASTM D 1056 GRADE 2A1 OR SAE J-18 GRADE 2A1  
REF DART SPEC M-4111N-S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4006</b>	REV. A
MFG. APPR.	<i>[Signature]</i>		SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE <b>UPPER RESTRAINT</b>	SCALE
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